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㉓ Proprietor: Nakamura, Kenji  
3-7, Nishiwaji 6-chome Higashiyodogawa-ku  
Osaka (JP)

㉔ Inventor: Nakamura, Kenji  
3-7, Nishiwaji 6-chome Higashiyodogawa-ku  
Osaka (JP)

㉕ Representative: Brandes, Jürgen, Dipl.-Chem.  
Dr. et al  
Thierschstrasse 8  
D-8000 München 22 (DE)

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## Description

The present invention relates to a method for producing a re-sealable dispenser-container which is suitable for containing sheet-like materials made from natural or synthetic fibers, such as tissue, paper, woven or knitted fabric, non-woven fabric, sheeted and cut cotton layers (cotton balls) for make-up and the like. More particularly, the re-sealable dispenser-container prepared according to the method of the present invention is suitable for containing sheets of fiber materials which are wetted with water, toilet water or a medicinal liquid.

Recently, tissues wetted with water, toilet water, medicinal liquid, e.g. disinfectant liquid, and the like have been utilized to clean hands or face, or to remove make-up. There are many kinds of containers for wet tissue, such as boxes and bags. Many conventional containers are plastic products made by injection molding or vacuum molding, so that the containers are bulky and are not suitable for carrying. Further, the cost of producing such containers is comparatively high.

Japanese Laid-open Utility Model Publication No. 49—4718 (4718/74) discloses a flat container made of a waterproofing sheet. The container is produced by folding the sheet into thirds, having a bottom part, a middle part and a top part and then bonding both side edges of the bottom part and the middle part. The middle part has an opening for taking out contents therefrom, whereas the top part acts as a lid for covering the opening and the top part has an adhesive layer coated on a surface of the top part facing the middle part, along the edges of the top part, in a  shape. The top part is re-sealably adhered to the middle part by means of the adhesive layer. Such a container may be portable and can be used to contain wet tissues. However, this container involves several difficulties. For example, odor of the adhesive infects contents because the air inside the container mixes with the air between the middle part and the top part, i.e. adhesive layer, because of the opening as a result the contents changed in odor or quality. It is difficult to automatically coat adhesive on the inside surface of the top part in a  shape and also difficult to form the adhesive layer at a constant position in each container, so that reliably sealing the top part and the middle part is not ensured. The container cannot be made in series production.

In US—A—4 156 493 there is disclosed a re-sealable dispenser-container for containing sheet-like materials for cosmetic or toilet use comprising;

a container body made of an impervious sheet-like material which wraps around said sheet-like materials for cosmetic or toilet use;

the container body being formed in a rectangular shape and having at least one opening;

a flap one end of which is attached to the

body at a position apart from an end of said opening and which has a pressure-sensitive adhesive surface; and

a non-adhesive member made of an impervious sheet-like material in a size at least the same as that of said opening formed on the container body and being adhered to the flap at a position corresponding to the opening.

A drawback of the dispenser-container of US—A—4 156 493 consists therein that it cannot be continuously manufactured. More specifically, the dispenser-container is formed from discontinuous and separate sheet-like material by filing the sheet-like material into two and sealing the three peripheral edges of the separate sheet-like material.

It is therefore an object of the present invention to provide a simple method for producing re-sealable dispenser-containers, according to which said re-sealable dispenser-containers can be manufactured continuously.

It is a further object of the present invention to provide a method producing a dispenser-container which is able to repeatedly and reliably seal an opening of a main container body for taking out contents therefrom.

It is a further object of the present invention to provide a method for producing a re-sealable dispenser-container in which the odor of adhesive to be used for sealing does not infect contents in the main container body.

It is a further object of the present invention to provide a method for producing a re-sealable dispenser-container which is able to assure user that nobody has taken the contents out of the container before the user uses it.

An even further object of the invention contemplates the provision of a method for producing a re-sealable dispenser-container easily and at comparatively low costs.

The dispenser-container manufactured according to the method of the invention can be used to contain a variety of items, i.e. paper, tissue, candy, nails, cotton balls etc. More particularly, the dispenser-container is very useful as it can contain sheet-like fiber materials such as tissue, gauze, paper, woven or knitted fabric, non-woven fabric, cotton balls for make-up, and so on, and especially suitable for wetted sheet-like fiber materials.

In a method for producing a re-sealable dispenser-container of the type defined in the prior art part of claim 1 (and likewise known from US—A—4,156,493), these objects in conformity with the present invention are reached by:

punching a line drawn in a closed elongated shape at a central portion in a sheet; disposing a flap with an adhesive surface on one side of said sheet in such a manner that the flap covers said punched line and that said adhesive surface of the flap contacts said side of said sheet; fixing one end portion of said flap to said sheet; disposing said sheet-like materials for cosmetic or toilet use on the opposite side of said sheet at a

position corresponding to said flap; wrapping said sheet-like materials for cosmetic or toilet use with the sheet so folded that longitudinal edges of the sheet are put upon each other at the central portion of the sheet; sealing the longitudinal edges of the sheet and sealing said sheet transversely; and cutting said sheet at a transversely sealed portion.

The re-sealable dispenser-container prepared according to the method of the invention is characterized in that the main container body has:

a first seal line extending in a longitudinal direction of said main container body at the central portion of said rectangular shape and connecting the edges of said impervious sheet-like material of said main container body to each other; and two second seal lines transversing to said first seal line at both short ends of said rectangular shape; said opening as formed on a surface of said main container body opposite to said first seal line is located at the central portion of said rectangular shape and extends in a longitudinal direction of said rectangular shape.

#### Brief Description of the Drawings

Fig. 1 is a perspective view of a re-sealable dispenser-container prepared according to the method of the present invention.

Fig. 2 illustrates an embodiment of the re-sealable dispenser-container as shown in Fig. 1, for convenience to show a state of a main container body before use, the flap being lifted.

Fig. 3 is a perspective view illustrating a state of the dispenser-container as shown in Fig. 2, that a part of the main body of the container is removed and attached to the flap as when someone commences using the container.

Fig. 4 is a perspective sectional view of another embodiment of the dispenser-container as shown in Fig. 1, for convenience to show a state of the main container body before use, the flap being lifted.

Fig. 5 is a perspective view illustrating a state of the dispenser-container shown in Fig. 4, that is, a non-adhesive member is taken out through an opening in the main body and is attached to a flap, when user begins using the dispenser-container.

Fig. 6 is a flow sheet illustrating one embodiment of the method for producing a re-sealable dispenser-container according to the invention.

Fig. 7 is a flow sheet illustrating another embodiment of the method for producing a re-sealable dispenser-container according to the invention.

The present invention will now be described in detail referring to the accompanying drawings. As shown in Fig. 1, a re-sealable dispenser-container prepared according to the method of the present invention comprises a main container body 1 made of impervious sheet-like material and provided with an open-

ing 2, a flap 3 positioned to cover the opening and attached to the main body at one end of the flap, which flap having a pressure-sensitive adhesive surface 4 facing the main body 1, and a non-adhesive member 5 adhered to the surface 4 at a position corresponding to the opening 2 in the main body 1.

The non-adhesive member 5 has the same or a larger area than the opening 2 and is positioned so as to substantially cover the opening 2 when the flap 3 is closed, that is, when the whole of the flap 3 contacts with the main body 1 and the pressure-sensitive adhesive surface 4 adheres to the main body 1, so that the non-adhesive member 5 can close the opening 2. Therefore, the non-adhesive member i.e. closing member 5 prevents the adhesive surface 4 from directly contacting the contents accommodated in the main body 1. The contents can be kept clean and the odor of the adhesive does not infect the contents. The dispenser-container of the invention can be used to contain various things, and the container is very suitable for containing things which should be kept clean or hygienic, such as something to eat, wetted gauze or tissue or cotton balls used for disinfecting or for make-up or for removing make-up and so on.

The shape of the opening 2 can be appropriately modified, such as circle, rectangle, diamond shape, ellipse, and the like.

A main container body 1 is a film made of synthetic resins such as polyethylene, polyester, polypropylene, polyvinyl chloride, polyamide, acetate, cellophane, and etc., and the film may be single layer or a laminated layer. The film may be a laminated layer of the above-mentioned film and aluminium sheet. The main container body as shown in Fig. 1 is a flat bag. Such bag is made of a sheet by bonding longitudinal edges of the sheet and then bonding both transverse end edges 6. The bonded longitudinal edges are not shown in Fig. 1 because they are in the back of the flat bag. However, a flat main container body may be produced by bonding the transverse edges and the longitudinal edges of two or more superimposed sheets. Bonding edges of film may be carried out by heat-sealing, ultrasonic sealing or high-frequency sealing.

A flap 3 may be made of the same material as mentioned-above in connection with the main container body. The flap may be fixed to the main body by means of heat-sealing, ultrasonic sealing, high-frequency sealing, or adhesive bonding. The fixing means is appropriately selected in accordance with material of the main body 1. The flap 3 has a larger area than the opening 2 in the main body 1 in order to completely cover the opening. The flap 3 may be in various shapes such as a circle, a rectangle, an ellipse, a racing track shape, and so on. The inside surface of the flap 3 facing the main container body 1 is coated with a pressure-sensitive adhesive such as an acrylic

adhesive, rubber adhesive, polyester adhesive, polyolefin adhesive, and the like, which adhesive may be coated by means of roller coating, knife coating or spray coating. If the flap 3 and the closing member 5 are transparent, it is convenient to see the state of the contents

A flap 3 may be provided with a projecting part 7 at the free end thereof in order to easily pick up the flap with the fingers to open the flap. Preferably the projecting part 7 is not coated with adhesive.

According to an embodiment of the invention as shown in Figs. 2 and 3, a non-adhesive member i.e. a closing member 5 is provided as part of the main body 1 before use. In Fig. 2, in order to clearly understand the state of the main body 1 before use a flap 3 is provisionally opened, but actually the flap 3 is closed and adheres to the main body 1. As shown in Fig. 2, a perforated line 8 drawn in a complete shape such as ellipse, a circle, a rectangle and so on, is formed on the main body 1 by means of punching. Before use, the flap 3 covers the perforated line 8 and adheres to the main body including the part encircled by the perforated line 8. Upon first use of the contents, one would take the projecting part 7 of the flap 3, pull up and open the flap 3. As shown in Fig. 3, while the flap 3 is being opened, the main body 1 is broken along the perforated line 8, so that the part encircled by the perforated line 8 adheres to the flap 3 and is removed from the main body 1. The removed part becomes a non-adhesive member 5 on the flap 3, and an opening 2 is formed in the main body 1 by the removal of said part. Then, the removed part i.e. non-adhesive member 5 is always attached to the flap 3.

After taking a portion of the contents out of the main body 1, the flap 3 is again closed to seal the main body and the non-adhesive member 5 is just fitted over the opening 2 and closes the opening 2.

According to another embodiment of the invention as shown in Figs. 4 and 5, a non-adhesive member 5 is provided as a member independent of a main body 1. Fig. 4 illustrates the state of the main body 1 and the non-adhesive member 5 before use, and a flap is provisionally opened, like Fig. 2. Before use, the non-adhesive member 5 is positioned inside the main body 1 to close the opening in the main body and is adhered to the adhesive surface 4 of the flap 3 through the opening. When first using the contents, the flap 3 is gradually lifted beginning from the free end of the flap, together with the non-adhesive member 5, the non-adhesive member 5 being taken out through the opening 2 (see Fig. 5). After using a portion of the contents the flap 3 with the non-adhesive member 5 is closed. Then the non-adhesive member 5 is always attached to the flap 3 and is able to cover and close the opening 2. In this embodiment, the non-adhesive member has a sufficient shape and area to completely cover the opening 2, preferably it has a shape similar to

and larger than the opening 2. The non-adhesive member 5 is preferably made of a comparatively flexible film of synthetic resins such as polyethylene, polypropylene, polyamide, polyvinyl chloride, and the like.

Regarding the embodiments as shown in Figs. 1 through 5, contents to be accommodated in the interior of a main container body 1 are preferably contained before completion of the forming of the dispenser-container from one or more sheet-like materials, i.e. before sealing the edges of a sheet or sheets longitudinally and transversely.

Referring to Fig. 6, one embodiment of the method of the invention will be described. An impervious continuous sheet for a main body of a dispenser-container, made of synthetic resins such as polyethylene, polypropylene, polyamide, polyester and so on, is fed from a roll of sheet 21 to a punching machine 22, wherein a perforated line drawn in a closed shape such as an ellipse, a circle, a rectangle etc. is punched in the sheet 21. Flaps 3, one side i.e. one surface of which has been coated with pressure-sensitive adhesive, having been made ready beforehand in such a manner that the flaps 3 are mounted on a roll of continuous sheet 23 for flaps. A flap 3 is removed from the sheet 23 and is disposed on the sheet 21 for a main body in such a way that the flap 3 covers the perforated line in the sheet 21 and that the adhesive surface of the flap faces the sheet 21, by means of a machine 24 for disposing a flap in place, which machine is a kind of labeling machine. The flap 3 is fixed to the sheet 21 at one end of the flap by a heat-sealer 25. Then the sheet 21 is guided by means of a guiding unit 26 comprising a plurality of guide rollers, so as to turn over the sheet 21. Contents 29, for example sheet-like fiber materials such as tissue, gauze, and the like, are mounted on the sheet 21 by means of a device 31 for supplying contents. Then the sheet is passed through a guide member 32 to wrap the contents 29 and to put the longitudinal edges of the sheet 21 together with each other. The longitudinal edges of the sheet 21 are sealed by means of a center heat-sealer 33. Further the sheet 21 is sealed in the transverse direction both in front and behind the contents by means of another heat-sealer 34, and the transverse sealed portion of the sheet 21 is cut by a cutting machine 35. As a result, the finished product, i.e. a re-sealable dispenser-container 36 is obtained.

Referring to Fig. 7, another embodiment of the method of the invention will be described. This method is almost similar to the method as shown in Fig. 6, except for the following points. According to the method of Fig. 7, an opening is formed in a sheet 21 for a main body of a container, by means of a punching machine 22. The opening is closed by a flap 3 with a pressure-sensitive adhesive surface. After turning over the sheet 21 which has been provided with a flap 3, a non-adhesive member 5, which has

been mounted on a sheet 27 previously, is disposed on the sheet 21 for a main body so as to cover the opening with the member 5, by means of a machine for disposing a non-adhesive member 5 in place, so that the member 5 is adhered to the adhesive surface of the flap 3 through the opening. Then, a final product 36 is produced in the same manner as described regarding Fig. 6.

According to the embodiments of the method of the present invention, a re-sealable dispenser-container and/or contents contained in a re-sealable dispenser of the invention can be produced in series, however each step in the process may be carried out intermittently or step by step.

It should be apparent that the present invention may be embodied in other specific forms without departing from the basic idea or scope of this invention, all of which are intended to be encompassed by these claims.

#### Claims

1. A method for producing a re-sealable dispenser-container for containing sheet-like materials for cosmetic or toilet use comprising a main container body (1) made of an impervious sheet-like material (21) which wraps around said sheet-like materials (29) for cosmetic or toilet use;

said main container body being formed in a rectangular shape and having at least one opening (2);

a flap (3) one end of which is attached to said main body (1) at a position apart from an end of said opening and which has a pressure-sensitive adhesive surface and

a non-adhesive member (5) made of an impervious sheet-like material in a size at least the same as that of said opening formed on said main container body (1) and being adhered to said flap (3) at a position corresponding to said opening, said method is characterized by:

punching a line drawn in a closed elongated shape at a central portion in a sheet (Figs. 6—7: 21);

disposing a flap (Figs. 1—7: 3) with an adhesive surface (Figs. 1—5: 4) on one side of said sheet (Figs. 6—7: 21) in such a manner that the flap (Figs. 1—7: 3) covers said punched line and that said adhesive surface (Figs. 1—5: 4) of the flap (Figs. 1—7: 3) contacts said side of said sheet (Figs. 6—7: 21); fixing one end portion of said flap (Figs. 1—7: 3) to said sheet (Figs. 6—7: 21);

disposing said sheet-like materials (Figs. 6—7: 29) for cosmetic or toilet use on the opposite side of said sheet (Figs. 6—7: 21) at a position corresponding to said flap (Figs. 1—5: 3);

wrapping said sheet-like materials (Figs. 6—7: 29) for cosmetic or toilet use with the sheet (Figs. 6—7: 21) so folded that longitudinal edges (Figs. 6—7: 17) of the sheet (Figs.

6—7: 21) are put upon each other at the central portion of the sheet (Figs. 6—7: 21);

sealing the longitudinal edges (Figs. 6—7: 17) of the sheet (Figs. 6—7: 21) and sealing said sheet (Figs. 6—7: 21) transversely; and

cutting said sheet (Figs. 6—7: 21) at a transversely sealed portion (Figs. 6—7: 6).

2. A method according to claim 1, wherein a perforated line (Fig. 2: 8) is formed by punching said line defining said closed elongated shape.

3. A method according to claim 1, wherein an elongated opening (Figs. 1—5: 2) is formed by punching, and said process further comprises disposing a non-adhesive member (Figs. 1, 3: 5) having a shape larger than said opening (Figs. 1—5: 2) on opposite side of the sheet (Figs. 6—7: 21) over said opening (Figs. 1—14: 2) so that the non-adhesive member (Figs. 1, 3: 5) is adhered to the adhesive surface of the flap (Figs. 1—7: 3) through said opening (Figs. 1—5: 2).

4. A re-sealable dispenser-container for containing sheet-like materials for cosmetic or toilet use obtained by the method according to claims 1 to 3, comprising:

a main container body (Figs. 1—5: 1) made of an impervious sheet-like material (Figs. 6—7: 21) which wraps around said sheet-like materials (Figs. 6—7: 29) for cosmetic or toilet use;

said main container body (Figs. 1—5: 1) being formed in a rectangular shape and having at least one opening (Figs. 1—5: 2);

a flap (Figs. 1—5: 3) one end of which is attached to said main body (Figs. 1—5: 1) at a position apart from an end of said opening (Figs. 1—5: 2) and which has a pressure-sensitive adhesive surface (Figs. 1—5: 4); and

a non-adhesive member (Figs. 1, 3—5: 5) made of an impervious sheet-like material in a size at least the same as that of said opening (Figs. 1—5: 2) formed on said main container body (Figs. 1—5: 1) and being adhered to said flap (Figs. 1—5: 3) at a position corresponding to said opening (Figs. 1—5: 2) characterized in that:

said main container body (Figs. 1—5: 1) has:

a first seal line (Figs. 6—7: 16) extending in a longitudinal direction of said main container body (Figs. 1—5: 1) at the central portion of said rectangular shape and connecting the edges (Figs. 6—7: 17) of said impervious sheet-like material (Figs. 6—7: 21) of said main container body (Figs. 1—5: 1) to each other; and

two second seal lines (Figs. 6—7: 6) transversing to said first seal line (Figs. 6—7: 16) at both short ends of said rectangular shape;

said opening (Figs. 1—5: 2) as formed on a surface of said main container body (Figs. 1—5: 1) opposite to said first seal line (Figs. 6—7: 16) is located at the central portion of said rectangular shape and extends in a longitudinal direction of said rectangular shape.

5. A re-sealable dispenser-container for sheet-like materials for cosmetic or toilet use

according to claim 4 wherein said main container body (Figs. 1—5: 1) contains wet tissues.

6. A re-sealable dispenser-container according to claim 4 wherein said non-adhesive member (Figs. 1, 3—5: 5) for covering said opening (Figs. 1—5: 2) has a shape similar to and larger than said opening (Figs. 1—5: 2) and being disposed on the opening (Figs. 1—4: 2) inside of the main body (Figs. 1—5: 1) before using the container, whereas after use, said member (Figs. 1, 3—5: 5) is drawn out through the opening (Figs. 1—5: 2) and attached to said flap (Figs. 1—5: 3).

#### Patentansprüche

1. Verfahren zur Herstellung eines wiederholt verschließbaren Vorratsbehälters für blattförmige Materialien für kosmetische Zwecke oder Toilettengebrauch mit einem Hauptbehälterkörper (1) aus einem dichten blattförmigen Material (21), der die blattförmigen Materialien (29) für kosmetische Zwecke oder Toilettengebrauch umhüllt, wobei gilt, daß der Hauptbehälterkörper in rechteckiger Form hergestellt ist und mindestens eine Öffnung (2) aufweist; mit einer Klappe (3), deren eines Ende am Hauptkörper (1) an einer Stelle im Abstand von einem Ende der Öffnung befestigt ist und die eine Oberfläche mit einem druckempfindlichen Klebstoff aufweist und mit einem nichtklebenden Teil (5) aus einem dichten blattförmigen Material und einer Größe, die mindestens gleich ist der Größe der Öffnung des Hauptbehälterkörpers (1) und an der Klappe (3) an einer Stelle haftet, die der Öffnung entspricht, dadurch gekennzeichnet, daß man in einen zentralen Abschnitt eines Blattes (Figuren 6—7: 21) ein Muster von geschlossener länglicher Form einbohrt oder einstanzt; daß man eine Klappe (Figuren 1—7: 3) mit einer klebenden Oberfläche (Figuren 1—5: 4) auf einer Seite des Blattes (Figuren 6—7: 21) in einer solchen Weise anordnet, daß die Klappe (Figuren 1—7: 3) das eingebohrte oder eingestanzte Muster bedeckt und daß die klebende Oberfläche (Figuren 1—5: 4) der Klappe (Figuren 1—7: 3) mit dieser Seite des Blattes (Figuren 6—7: 21) in Kontakt gelangt; daß man einen Endabschnitt der Klappe (Figuren 1—7: 3) auf dem Blatt (Figuren 6—7: 21) befestigt; daß man die blattförmigen Materialien (Figuren 6—7: 29) für kosmetische Zwecke oder Toilettengebrauch auf der gegenüberliegenden Seite des Blattes (Figuren 6—7: 21) an einer Stelle entsprechend der Klappe (Figuren 1—5: 3) anordnet; daß man die blattförmigen Materialien (Figuren 6—7: 29) für kosmetische Zwecke oder Toilettengebrauch mit dem Blatt (Figuren 6—7: 21) umhüllt, so daß die Längskanten (Figuren 6—7: 17) des Blattes (Figuren 6—7: 21) im Mittelbereich des Blattes (Figuren 6—7: 21) aufeinander gelangen; daß man die Längskanten (Figuren 6—7: 17) des Blattes (Figuren 6—7: 21) versiegelt und das Blatt (Figuren 6—7: 21) quer versiegelt und daß

man das Blatt (Figuren 6—7: 21) in dem Bereich der Querversiegelung (Figuren 6—7: 6) durchtrennt.

2. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß man ein Perforationsmuster (Figur 2: 8) erzeugt, indem man das Muster, das die geschlossene längliche Form definiert, einbohrt oder einstanzt.

3. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß man durch Ausstanzen eine längliche Öffnung (Figuren 1—5: 2) erzeugt und daß man ferner ein nicht-klebendes Teil (Figuren 1, 3: 5) eines Formates, das größer ist als die Öffnung (Figuren 1—5: 2) auf die gegenüberliegende Seite des Blattes (Figuren 6—7: 21) über der Öffnung (Figuren 1—14: 2) anordnet, so daß das nichtklebende Teil (Figuren 1, 3: 5) an der klebenden Seite der Klappe (Figuren 1—7: 3) über der Öffnung (Figuren 1—5: 2) zur Haftung gebracht wird.

4. Wiederholt verschließbarer Vorratsbehälter zur Aufnahme von blattförmigen Materialien für kosmetische Zwecke oder Toilettengebrauch, erhalten nach dem in Ansprüchen 1 bis 3 gekennzeichneten Verfahren, mit

einem Hauptbehälterkörper (Figuren 1—5: 1), hergestellt aus einem dichten blattförmigen Material (Figuren 6—7: 21), welcher die blattförmigen Materialien für kosmetische Zwecke oder Toilettengebrauch (Figuren 6—7: 29) umhüllt; wobei der Hauptbehälterkörper (Figuren 1—5: 1) in rechteckiger Form hergestellt ist und mindestens eine Öffnung (Figuren 1—5: 2) aufweist; mit einer Klappe (Figuren 1—5: 3), von der ein Ende an dem Hauptkörper (Figuren 1—5: 1) an einer Stelle seitlich von dem einen Ende der Öffnung (Figuren 1—5: 2) befestigt ist und die eine Oberfläche mit einem druckempfindlichen Klebstoff (Figuren 1—5: 4) aufweist; und mit

einem nicht-klebenden Teil (Figuren 1, 3—5: 5) aus einem dichten, blattförmigen Material einer Größe, die mindestens der Größe der Öffnung (Figuren 1—5: 2) gleich ist, die sich im Hauptbehälterkörper (Figuren 1—5: 1) befindet und das an der Klappe (Figuren 1—5: 3) an einer Stelle entsprechend der Öffnung (Figuren 1—5: 2) haftet, dadurch gekennzeichnet, daß der Hauptbehälterkörper (Figuren 1—5: 1) aufweist:

eine erste Versiegelungsstrecke (Figuren 6—7: 16), die sich in Längsrichtung des Hauptbehälterkörpers (Figuren 1—5: 1) im zentralen Bereich der rechteckigen Form erstreckt und die Kanten (Figuren 6—7: 17) des dichten blattförmigen Materials (Figuren 6—7: 21) des Hauptbehälterkörpers (Figuren 1—5: 1) miteinander verbindet und

zwei zweiten Versiegelungsstrecken (Figuren 6—7: 6), die quer zur ersten Versiegelungsstrecke (Figuren 6—7: 16) an den beiden kurzen Enden der rechteckigen Form verlaufen;

wobei die Öffnung (Figuren 1—5: 2), die sich in einer Oberfläche des Hauptbehälterkörpers (Figuren 1—5: 1) gegenüber der ersten Versie-



gelungsstrecke (Figuren 6—7: 16) befindet, im zentralen Bereich der rechteckigen Form sitzt und sich in Längsrichtung der rechteckigen Form erstreckt.

5. Wiederholt verschließbarer Vorratsbehälter für blattförmige Materialien für kosmetische Zwecke oder Toilettengebrauch nach Anspruch 4, dadurch gekennzeichnet, daß der Hauptbehälterkörper (Figuren 1—5: 1) feuchte Tücher enthält.

6. Wiederholt verschließbarer Vorratsbehälter nach Anspruch 4, dadurch gekennzeichnet, daß das nicht-klebende Teil (Figuren 1, 3—5: 5) zum Abdecken der Öffnung (Figuren 1—5: 2) eine Form hat, die der Öffnung (Figuren 1—5: 2) ähnlich und größer ist und sich vor Verwendung des Behälters in der Öffnung (Figuren 1—4: 2) innerhalb des Hauptkörpers (Figuren 1—5: 1) befindet, während das Teil (Figuren 1, 3—5: 5) nach Verwendung des Behälters durch die Öffnung (Figuren 1—5: 2) gezogen und an der Klappe (Figuren 1—5: 3) befestigt wird.

#### Revendications

1. Un procédé de fabrication d'un récipient distributeur rescellable destiné à contenir des matériaux du type en feuille à usage cosmétique ou de toilette, comprenant un corps de récipient principal (1) fait d'une matière imperméable (21) du type en feuille, qui enveloppe lesdites matières (29) du type en feuille à usage cosmétique ou de toilette, ledit corps de récipient principal étant formé à une forme rectangulaire et ayant au moins une ouverture (2); un volet (3) dont une extrémité est attachée audit corps principal (1) dans une position éloignée d'une extrémité de ladite ouverture et qui possède une surface adhésive sensible à la pression; et un élément non adhésif (5) fait d'une matière imperméable du type en feuille, d'une dimension au moins égale à celle de ladite ouverture formée sur ledit corps principal (1) du récipient et collé audit volet (3) dans une position qui correspond à ladite ouverture, ledit procédé étant caractérisé en ce que: on perce une ligne tracée selon une forme allongée fermée dans une position centrale dans une feuille (figures 6—7: 21); on dispose un volet (figures 1—7: 3) présentant une surface adhésive (figures 1—5: 4) sur une face de ladite feuille (figures 6—7: 21) de telle manière que le volet (figures 1—7: 3) recouvre ladite ligne perforée et que ladite surface adhésive (figures 1—5: 4) du volet (figures 1—7: 3) soit en contact avec ledit côté de ladite feuille (figures 6—7: 21); on fixe une partie terminale dudit volet (figures 1—7: 3) à ladite feuille (figures 6—7: 21); on dispose lesdites matières du type en feuille (figures 6—7: 29) à usage cosmétique ou de toilette sur la face opposée de ladite feuille (figures 6—7: 21) dans une position correspondant audit volet (figures 1—5: 3); on enveloppe lesdites matières du type en feuille

(figures 6—7: 29) à usage cosmétique ou de toilette avec la feuille (figures 6—7: 21) repliée de manière que les bords longitudinaux (figures 6—7: 17) de la feuille (figures 6—7: 21) soient placés l'un sur l'autre dans la partie centrale de la feuille (figures 6—7: 21); on scelle les bords longitudinaux de la feuille (figures 6—7: 17) et on scelle ladite feuille (figures 6—7: 21) transversalement; et on coupe ladite feuille (figures 6—7: 21) dans une partie scellée transversalement (figures 6—7: 6).

2. Un procédé selon la revendication 1, dans lequel une ligne perforée (figure 2: 8) est formée en perforant ladite ligne définissant ladite forme allongée fermée.

3. Un procédé selon la revendication 1, dans lequel une ouverture allongée (figures 1—5: 2) est formée par perforation, et ledit procédé comprenant encore les phases dans lesquelles on dispose un élément non adhésif (figures 1—3: 5) ayant une forme plus grande que celle de ladite ouverture (figures 1—5: 2) sur la face opposée de la feuille (figures 6—7: 21), par dessus l'ouverture (figures 1—4: 2) de sorte que l'élément non adhésif (figures 1—3: 5) est collé à la surface adhésive du volet (figures 1—5: 3) à travers ladite ouverture (figures 1—5: 2).

4. Un récipient distributeur rescellable destiné à contenir des matériaux du type en feuille à usage cosmétique ou de toilette contenu par le procédé selon les revendications 1 à 3, qui comprend: un corps principal de récipient (figures 1—5: 1) fait d'une matière imperméable du type en feuille (figures 6—7: 21) qui enveloppe lesdites matières du type en feuille (figures 6—7: 29) à usage cosmétique ou de toilette; ledit corps principal de récipient (figures 1—5: 1) étant formé à une forme rectangulaire et ayant au moins une ouverture (figures 1—5: 2); un volet (figures 1—5: 3) dont une extrémité est attachée audit corps principal (figures 1—5: 1) dans une position éloignée d'une extrémité de ladite ouverture (figures 1—5: 2) et qui possède une surface adhésive sensible à la pression (figures 1—5: 4); et un élément non adhésif (figures 1—3: 5) fait d'une matière imperméable du type en feuille d'une dimension au moins égale à celle de ladite ouverture (figures 1—5: 2) formée sur ledit corps principal du récipient (figures 1—5: 1) et étant collé audit volet (figures 1—5: 3) dans une position qui correspond à ladite ouverture (figures 1—5: 2), caractérisé en ce que: ledit corps principal de récipient (figures 1—5: 1) possède: une première ligne de scellement (figures 6—7: 16) s'étendant dans une direction longitudinale dudit corps principal du récipient (figures 1—5: 1) dans la partie centrale de ladite forme rectangulaire et reliant les bords (figures 6—7: 17) de ladite matière imperméable du type en feuille (figures 6—7: 21) dudit corps principal du récipient (figures 1—5: 1) l'un à l'autre; et deux deuxième lignes de scellement (figures 6—7: 6) transversalement à

ladite première ligne de scellement (figures 6—7: 16) aux deux petites extrémités de ladite forme rectangulaire; ladite ouverture (figures 1—5: 2), formée sur une surface dudit corps principal de récipient (figures 1—5: 1) à l'opposé de ladite première ligne de scellement (figures 6—7: 16) est placée dans la partie centrale de ladite forme rectangulaire et s'étend dans une direction longitudinale de ladite forme rectangulaire.

5. Un récipient distributeur rescellable pour matière du type en feuille, à usage cosmétique ou de toilette selon la revendication 4, dans lequel ledit corps principal du récipient (figures

1—5: 1) contient des tissus humectés.

6. Un récipient distributeur rescellable selon la revendication 4, dans lequel ledit élément non adhésif (figures 1—3—5: 5) destiné à couvrir ladite ouverture (figures 1—5: 2) possède une forme analogue à celle de ladite ouverture et plus grande que celle-ci (figures 1—5: 2) et étant disposée sur l'ouverture (figures 1—4: 2) à l'intérieur dudit corps principal (figures 1—5: 1) avant l'utilisation du récipient tandis que, après utilisation, ledit élément (figures 1—3—5: 5) est arraché à travers l'ouverture (figures 1—5: 2) et attaché audit volet (figures 1—5: 3).

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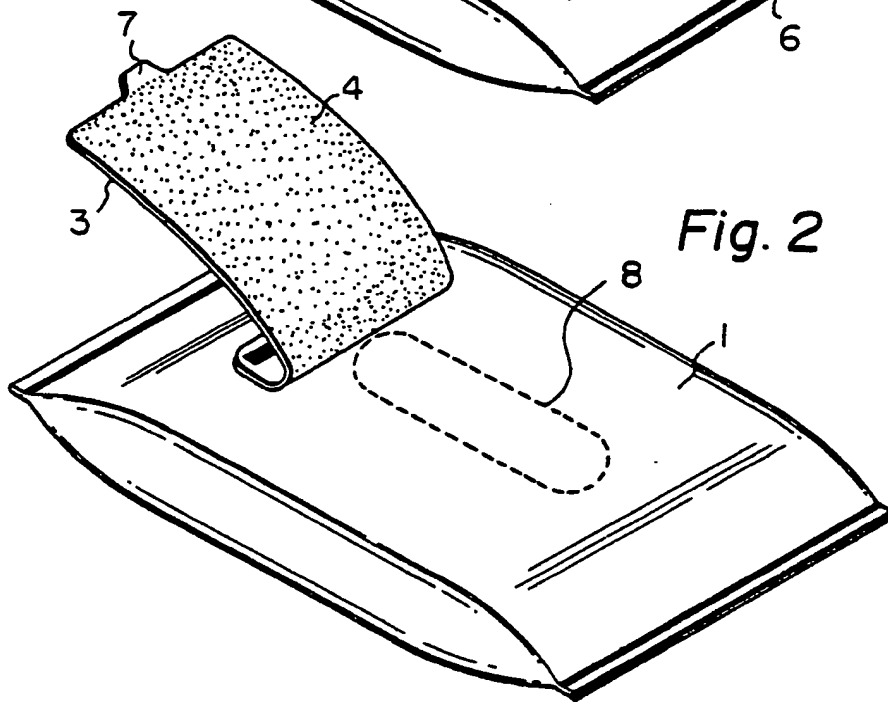
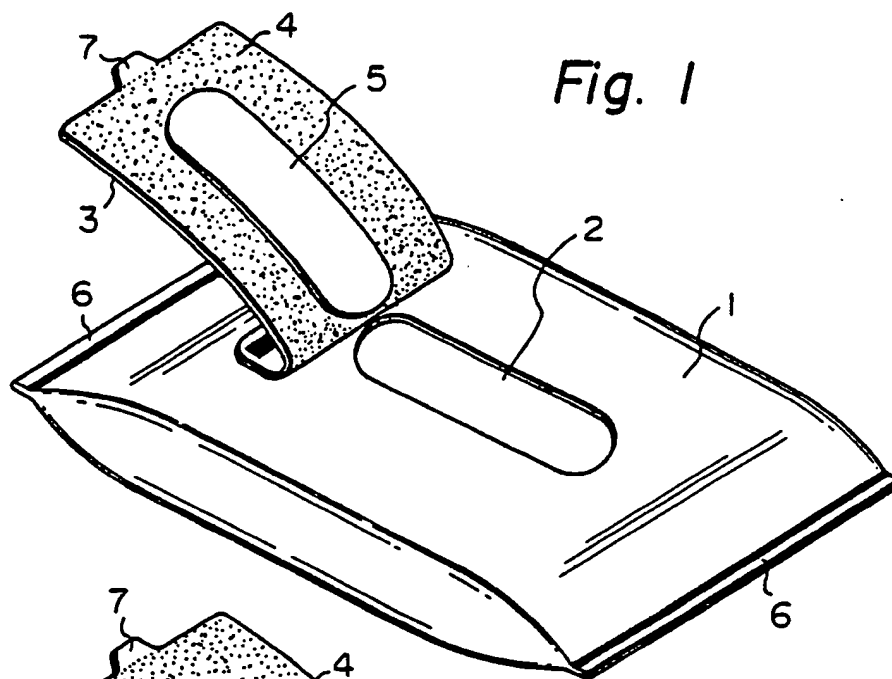
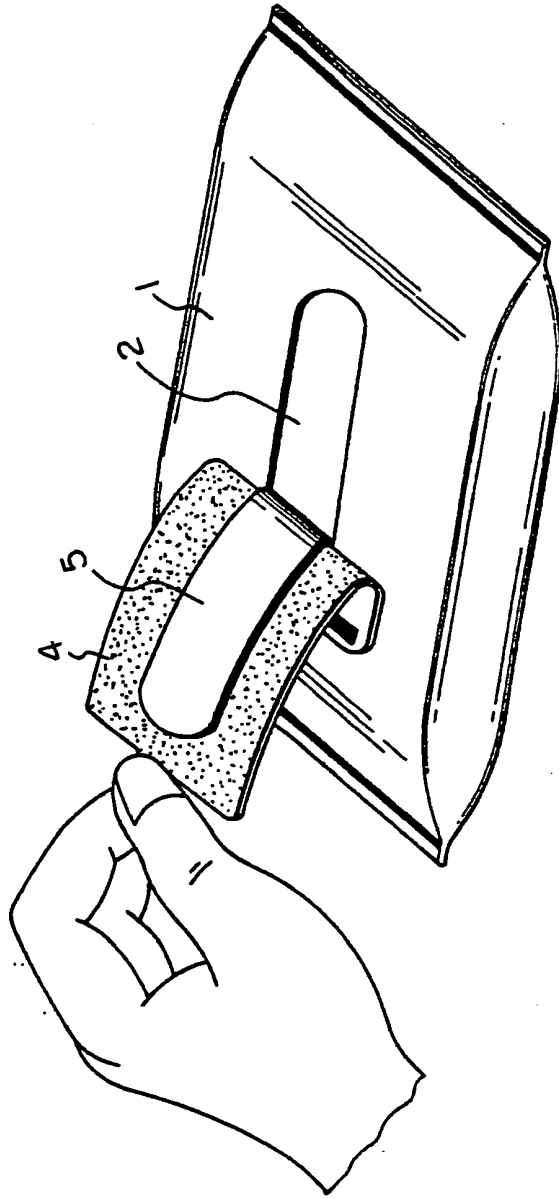
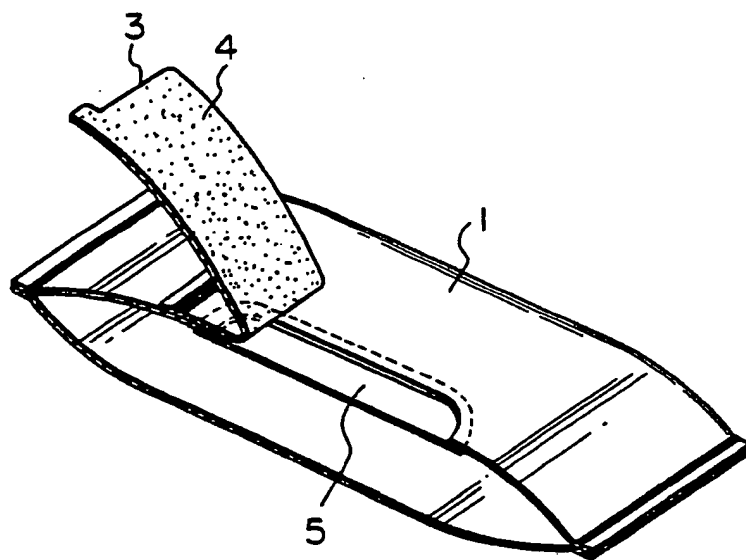


Fig. 3



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*Fig. 4*



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Fig. 5

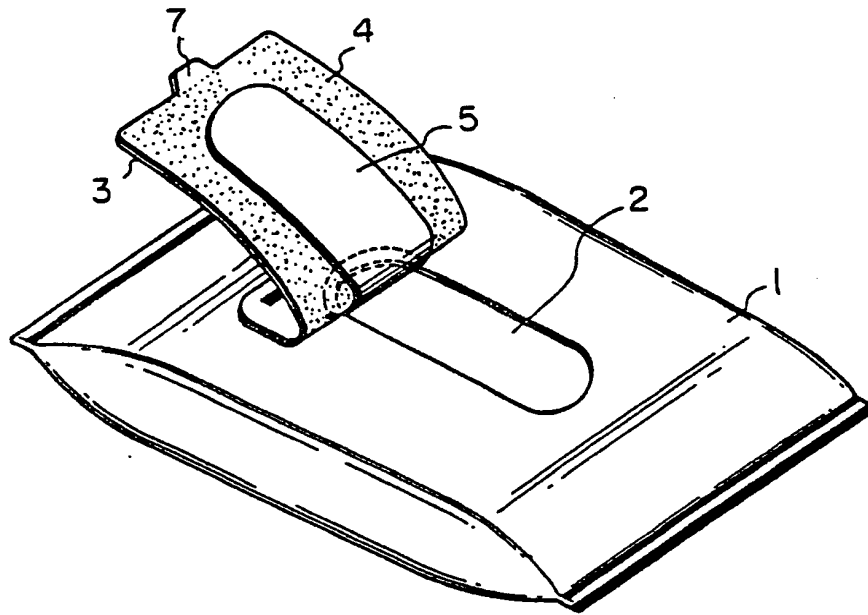


Fig. 6

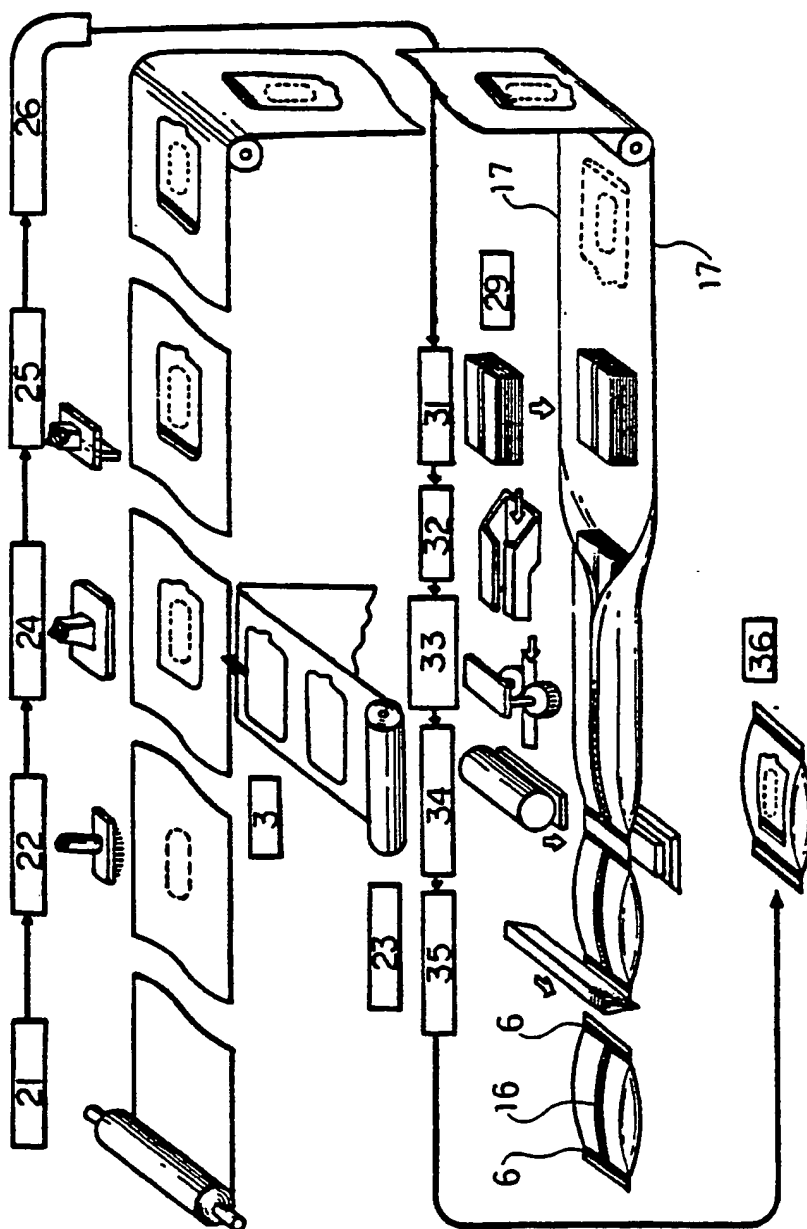


Fig. 7

